

OLD Style! Sept. 9

Dart Aerospace Ltd.

Date: Tuesday, 15/08/2006 3:04:55 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STA 155 BRACKET		
Job Number	: 28199					
Estimate Number	: 11040					
P.O. Number	: N/A					
This Issue	: 15/08/2006		S.O. No.	: N/A		
Prsht Rev.	: NC					
First Issue	: N/A		Type	: SMALL /MED FAB		
Previous Run	: 27685					
Written By	:					
Checked & Approved By	:					
Comment	: Est. A00.11.06 New Issue EC Est. B06.05.30 Blanks on wtjetEC			Due Date	: 09/08/2006	

Additional Product

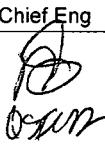
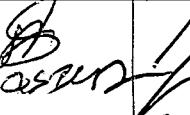
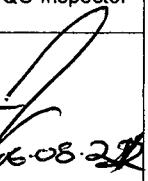
Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0500X12000	6061-T6 Bar .50" x 12.0"	
		Comment: Qty.: 0.7875 f(s)/Unit Total : 6.3000 f(s) 6061-T6 Bar .50" x 12.0" Material: 6061-T6 bar 12.00" x 0.50" Batch: M10/263	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Template DT8534 Dwg Rev: B Prog Rev: B	
		2-Deburr if necessary	<i>SAP 06.08.16 (8)</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA103	<i>JL 06/08/21</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>JL 06/08/21</i>
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>JL 06/08/22</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/08/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/08/21	3	D2804-2 was placed crooked on the mill line, And at the top hole location was not machined due to the hole being to close to the edge.	 OGM	Scans & destroy & replace. ensure part is placed properly in machine.	J.L. 06/08/21		 06/08/21	 06/08/21

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 3:04:55 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET

Job Number: 28199

Part Number: D28042

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr

SA 06.08.22

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

PL 06/08/29 ⑧

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock.

Location: ST156

PL 06/08/30 ⑧

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

PL 06/08/31 ⑧

Job Completion



LO 06/08/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

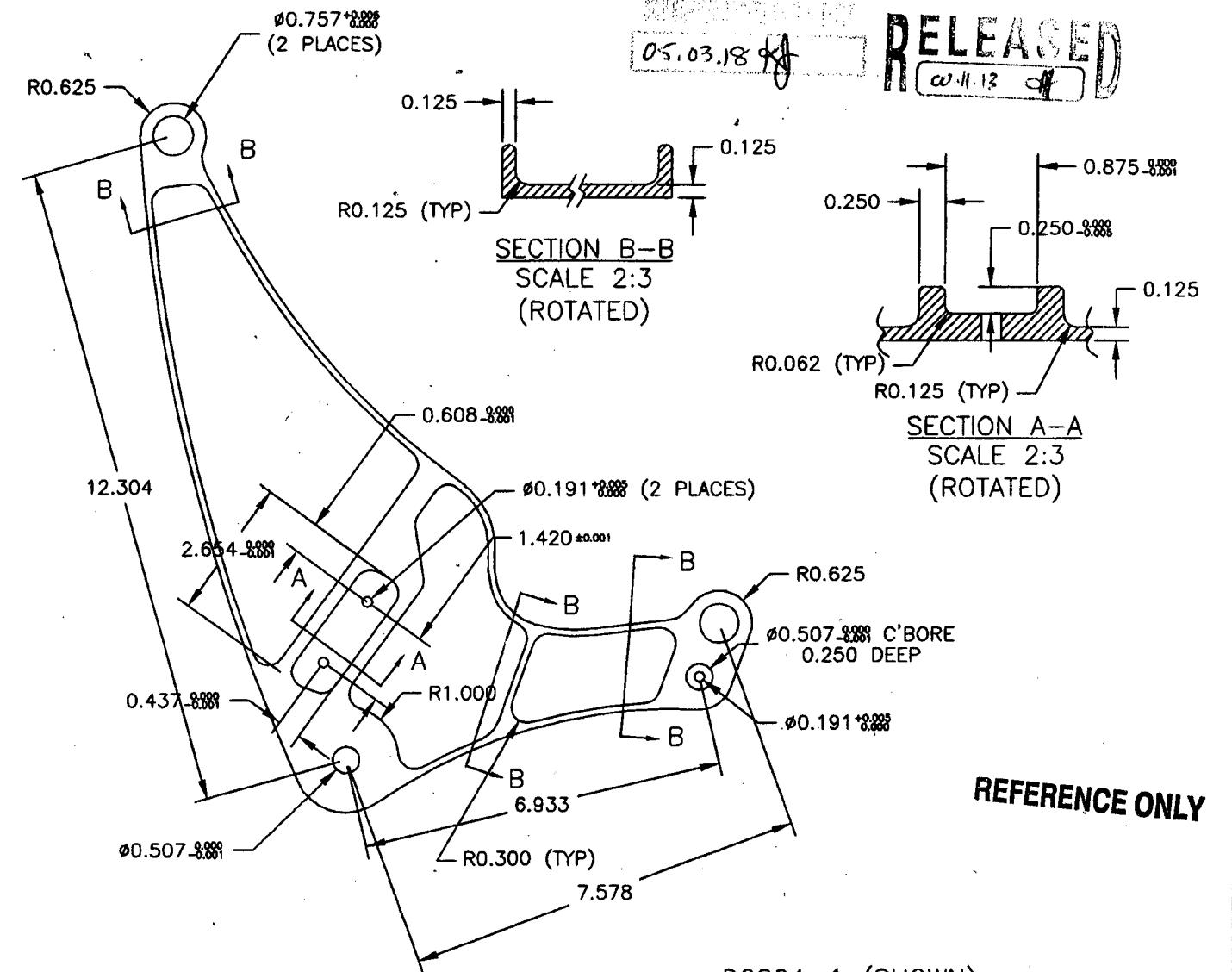
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
CP	CP	D2804	SHEET 1 OF 2
DATE		TITLE	SCALE
00.11.07		STA 155 BRACKET	1:3
A	00.11.07	NEW ISSUE	
A1	01.03.14	ADD D2804-043/-044 CP	



MACHINE PER DRAWING FILE "D2804-A1.DWG"

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK

DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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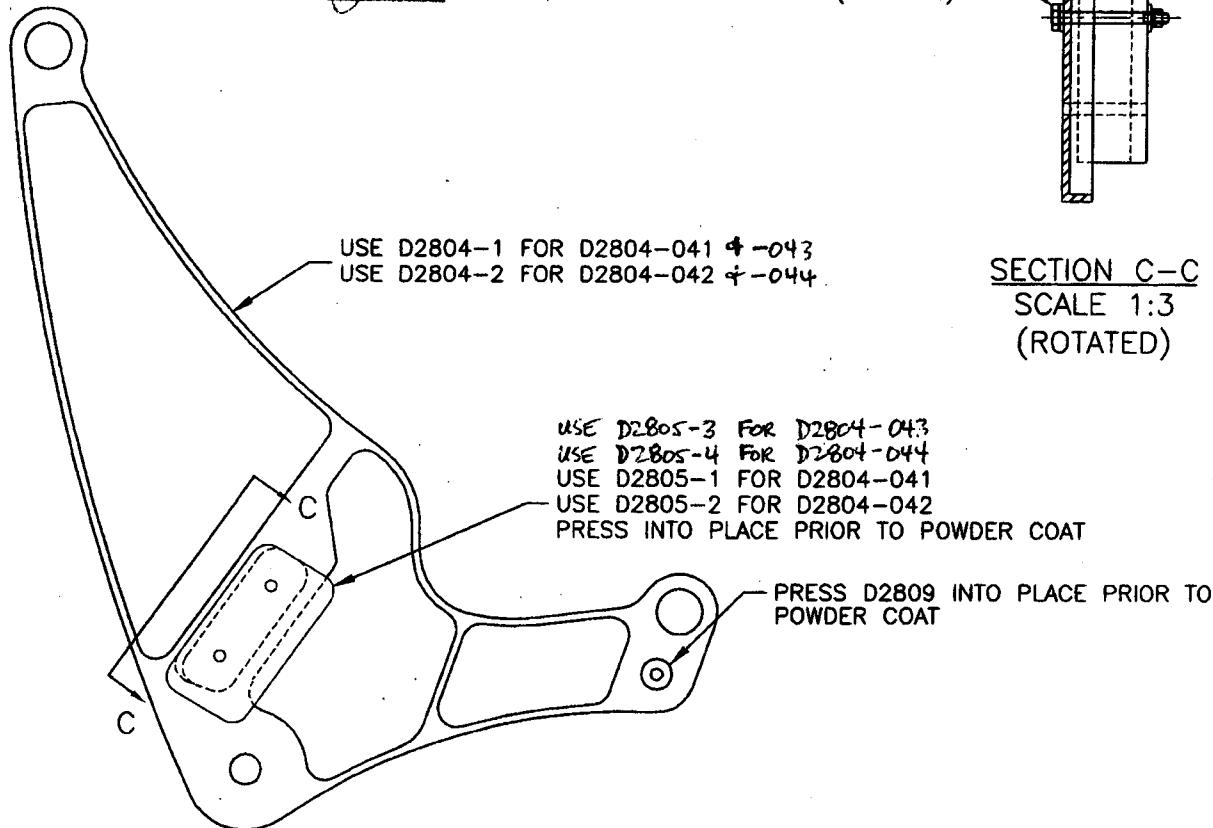
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DART

DESIGN <i>AA</i>	DRAWN BY <i>AA</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>GP</i>	APPROVED <i>AA</i>	DRAWING NO. D2804
DATE 00.11.07	TITLE STA 155 BRACKET	REV. A SHEET 2 OF 2 SCALE 1:3

RELEASED
00.11.13

SUPERCEDED BY

05.03.18 *AA*

SECTION C-C
SCALE 1:3
(ROTATED)

D2804-041 ASSEMBLY (SHOWN) → D2804-043 SIMILAR
D2804-042 ASSEMBLY (OPPOSITE) → D2804-044 SIMILAR *A1*

FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6) OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3

DART AEROSPACE LTD		Work Order:	
Description: STA 155 Bracket		Part Number:	D2804-2
Inspection Dwg: D2804 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	.126	✓			
0.125	+/-0.010	.128	✓			
R0.125	+/-0.010	.125	✓			
0.250	+/-0.010	.250	✓			
0.250	+0.000/-0.005	.248	✓			
0.875	+0.000/-0.001	.875	✓			
R0.062	+/-0.010	.062	✓			
Ø0.757	+0.005/-0.000	.759	✓			
R0.625	+/-0.010	.625	✓			
12.304	+/-0.005	12.304	✓			
Ø0.507	+0.000/-0.001	.5065	✓			
0.437	+0.000/-0.001	.437	✓			
0.608	+0.000/-0.001	—				cannot measured caliper
Ø0.191	+0.005/-0.000	.193	✓			
1.420	+0.001/-0.001	1.420	✓			
0.250 deep	+/-0.010	.250	✓			
6.933	+/-0.005	6.933	✓			
7.578	+/-0.005	7.578				

Measured by:	J.L.
Date:	06/08/21

Audited by:	gml
Date:	06/08/21

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	